

ASAP

Date: Monday, 3/17/2008 11:56:45 AM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 1/4 TURN FASTNER RAIL (BLACK)
Job Number : 38022	
Estimate Number : 10096	
P.O. Number :	Part Number : D103858B
This Issue : 3/17/2008 S.O. No. :	Drawing Number : D1038
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : B
Previous Run : 34968	Material :
Written By :	Due Date : 3/31/2008 Qty: 100 Um: Each
Checked & Approved By : <u>JA 0803 17</u>	
Comment : Est: E 03.05.02 Reformat; Added label KJ/RF	
Est Rev:F 06-08-16 Updated Packaging Procedures JLM	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL  
Create white labels and bag them

08.04.08 JD

2.0	D2023	Extrusion, Fastener Rail
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Comment: Qty.: 1.9030 f(s)/Unit Total : 190.3000 f(s)  
Extrusion, Fastener Rail

M21907

3.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut extrusion D2023 to length 21.81" (+0.06/-0.00) Batch# : M21907 H.A 08/03/20

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
1-Machine as per Folio and Dwg D1038-58

SL/H.A/ 08/03/20

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL/H.A/ 08/03/20

6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SL 08/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Description:

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

*08/03/25 (100)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SP015 08/03/25 (X100)*

9.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES  
Issue P/O: 5988  
Black Anodize as per Dwg D1038

*08/03/26 (100)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage

*8/4/2 (100)*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

*08/04/03 (X100) counts*

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389

Batch: M18727  
M104298

2-Grind wire flush and deburr

3-Clean

*M108/04/07*

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08/04/07 (X100) counts*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: Packaging

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

08-04-08.

CYon

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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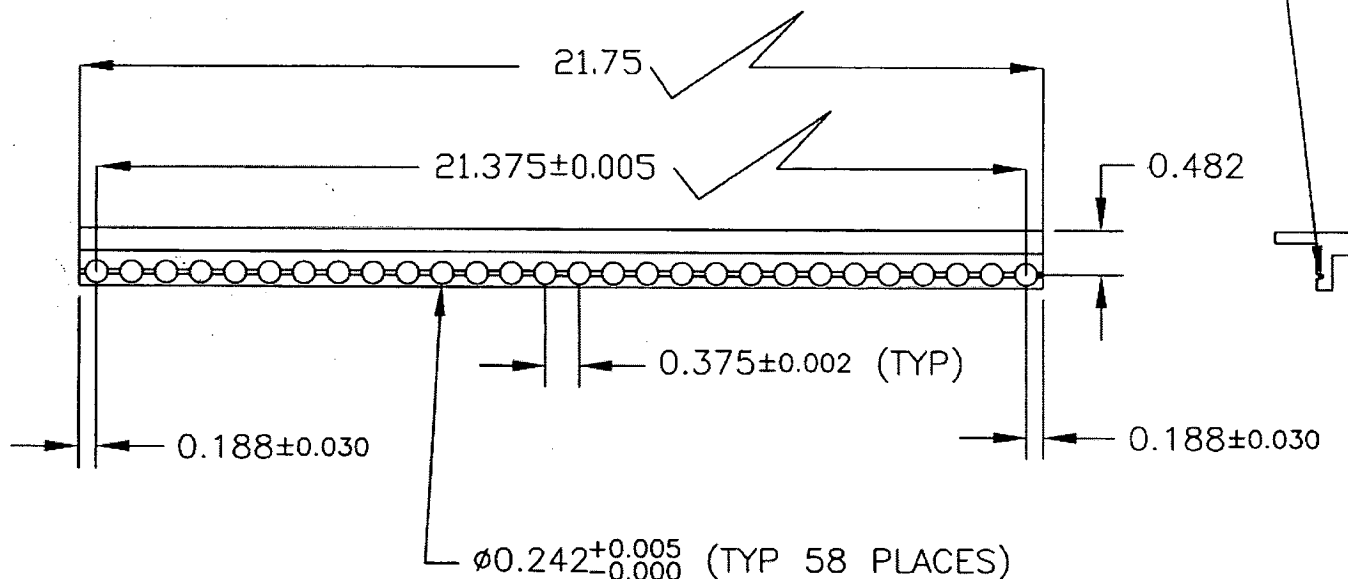


RELEASED

05.03.31

DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
04	04	D1038
DATE		TITLE
05.02.02		1/4 TURN FASTENER RAIL
	91.05.05	NEW ISSUE
A	04.05.14	UPDATE TOLERANCE
B	05.02.02	REDRAWN, UPDATE NOTES

STAKE  $\phi 0.50$  TYPE 302 STAINLESS  
STEEL WIRE FULL LENGTH  
(REF DART SPEC M302SW.050)



**D1038-58 1/4 TURN FASTENER RAIL**

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE  
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10

3) ALL DIMENSIONS ARE IN INCHES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38022





**TNM****ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified  
approuvé NADCAP approved

63408

31-Mar-2008

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE****CERTIFICAT DE CONFORMITE****NO. DE COMMANDE:****PURCHASE ORDER/****214586**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	5	5	D2224 B 37744 -	RED ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
2	31	31	D2091 B 30137 -	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2
3	100	100	D1038-58B B 38022 -	BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2

**REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL**

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: \_\_\_\_\_

Directeur de la Qualité / Q.A. Manager